

Work Order ID 48619

July 6, 2009 2:20:10 PM



Page 1

Item ID: D119-675-012

Accept



Setup Start



Revision ID: N/A

Stop



Item Name: Heli-Access-Step RH

Start Date: 07/06/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference: RETURN 09-066

Approvals: Process Plan: MF

Date: 6/7/09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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N/A	Rev N/A
-----	---------

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 119-675-012 CHG003



110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging



120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

=> 8096707 @ (RH)

Work Order ID 48619

July 6, 2009 2:20:10 PM



Page 2

Item ID: D119-675-012

Accept



Setup Start



Revision ID: N/A

Stop



Item Name: Heli-Access-Step RH

Start Date: 07/06/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D119-675-012

Location: _____

NCC

Reg 7/7 ①

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

6/02/11

W 09.07.07

Date: Wednesday, 17/06/2009 9:32:44 AM
User: Melanie Fauteux

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D119-675-012 STEP
Job Number	: 48619		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D119675012
This Issue	: 17/06/2009 S.O. No. :	Drawing Number	: R09-066
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: <u>2 0906-17</u>	Due Date	: 24/06/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>MF 09-06-17</u>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D119675012	Heli-Access-Step RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Heli-Access-Step RH

Original B46572 @ CHG003

2.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

2 0906-17 (1)

for CL 09/07/07

Step and lugs are in good condition, and only need to be cleaned and touched up. New hardware & paper work required.

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Clean the D3043-042 step; and the D3041-1 lug clamps, and touch-up with Imron white, as neatly as possible.

D3043-042 step required some minor wet sanding and polishing where identified.

BR 09-07-2 (1)

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

Sc 09/07/02 (4)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick the following items.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 17/06/2009 9:32:44 AM
User: Melanie Fauteux

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D119-675-012 STEP

Job Number: 48619

Part Number: D119675012

Job Number:



Seq. #:

Machine Or Operation:

Description :

Ensure the following are included in the kit, and are clean and complete:

- 5 1x D3043-042 step
5 4 x D3041-1 clamp - B42946
5 2x D3041-3 clamp 46615 40494
4x D3042-1 clamp

****See attached original w/o for the original batch numbers****

CL09107107.

New labels, and decals with the new batch # @ CHG003 are required along with new paperwork.

501263

6.0

D2182B032

Rubber Cushion



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D2182B032 Rubber Cushion

B39986

9/1/12

SV

7.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block

47794

9/1/12

SV

8.0

D26173

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D2617-3 Bushing

48613

9/1/12

SV

9.0

D26175

Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

8 D2617-5 Bushing

B548168

9/1/12

SV

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 17/06/2009 9:32:44 AM
User: Melanie Fauteux

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D119-675-012 STEP

Job Number: 48619

Part Number: D119675012

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2732

Rubber Extrusion

FAI



Comment: Qty.: 1.0660 f(s)/Unit Total : 1.0660 f(s)

Qty Part #

Description

Batch

4 D2732-032

Rubber cushion

B43118

9/11/12

54

11.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

8 AN4-12A Bolt *M111605*

9/11/12

56

12.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 AN4-11A Bolt *M106605*

9/11/12

56

13.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 AN4-15A Bolt *M110399*

9/11/12

51

14.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer *M111279*

9/11/12

50

Date: Wednesday, 17/06/2009 9:32:44 AM
User: Melanie Fauteux

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D119-675-012 STEP

Job Number: 48619

Part Number: D119675012

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS21042L4

Nut



(12)

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4) M110501

1 paperwork package from Step 1

9/7/12

54

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

****Ensure the parts form 5.0 are included, and are identified with the original batch #'s per the original w/o attached****

LOG

8/9/12

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-675-012

Location: _____

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



DART Dart Aerospace Ltd. 1270 ABERDEEN ST HAWKESBURY, ON CANADA K6A 1K7		TC APPROVAL # 09-89 TEL: 1-613-632-5200	
PIN	D119-675-012	CHG	CHG003
DESC.	Heli-Access-Step, RH	STC	SR00948SE
LOT	B46572	STC	
MODEL	Agusta A119/AW119MKII	STC	
MADE IN CANADA		D2729-1	

Date: Thursday, 19/03/2009 11:01:57 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: A119 STEP INSTALLATION R/H
Job Number	: 46572		
Estimate Number	: 10132		
P.O. Number	:	Part Number	: D119675012
This Issue	: 19/03/2009 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 42917	Material	:
Written By	:	Due Date	: 10/04/2009 Qty: 4 Um: Each
Checked & Approved By	: <u>JLD 09.03.19</u>		
Comment	: Est Rev:D Removed Manufacturing JLM 05-11-01 Est Rev:E change to rev.b as per ECN1107 DD verified by:		

REFERENCE ONLY

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



H for JLD 09/04/09



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP 119-675-012 CHG003

S 09/04/09

2.0 46572A A119 STEP WELDMENT RH



Comment: Sub-Component A119 STEP WELDMENT RH

1 x D3043-042 Batch

46572A SO

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

4.0 D2182B032 Rubber Cushion



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B032 Rubber Cushion

B39986

measured 5 7/3/31

re-packing in IP

5.0 D2274 Radius Block



New

Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block

(16)

B44547

9/3/31

50

Date: Thursday, 19/03/2009 11:01:57 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP INSTALLATION R/H

Job Number: 46572

Part Number: D119675012

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D26173

Bushing



New



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D2617-3 Bushing B44360

7.0

D26175

Spacer



New



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

8 D2617-5 Bushing 345663 24 46607

8.0

D2732

Rubber Extrusion



re-package



Comment: Qty.: 1.0660 f(s)/Unit Total : 4.2640 f(s)

Qty

Part #

Description

Batch

4 D2732-032 Rubber cushion 38509

New

9.0

D30411

Clamp



re-pack



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D3041-1 Clamp 42946

clean touch-up

10.0

D30413

Clamp



re-pack still in bag



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

2 D3041-3 Clamp 40494

B46015 x5

809/04/09 (x4)
9/3/20

Date: Thursday, 19/03/2009 11:01:57 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP INSTALLATION R/H

Job Number: 46572

Part Number: D119675012

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D30421

Clamp



Per Package



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D3042-1 Clamp B340495

12.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

8 AN4-12A Bolt M110704

(10) New
M109754

13.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 AN4-11A Bolt M106605

New

14.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 AN4-15A Bolt M110399

New

15.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer M108161

26
M110363

New

9/3/31

Date: Thursday, 19/03/2009 11:01:57 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP INSTALLATION R/H

Job Number: 46572

Part Number: D119675012

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS21042L4

Nut



(4x)

Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4) M107499

1 paperwork package from Step 1

} New 36
M107287
9/3/31

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Sotoalos 4 R/H

18.0

PACKAGING 1

PACKAGING RESOURCE #1



(1x)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-675-012

Location: 82

Rev C 9/4/9

SP

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



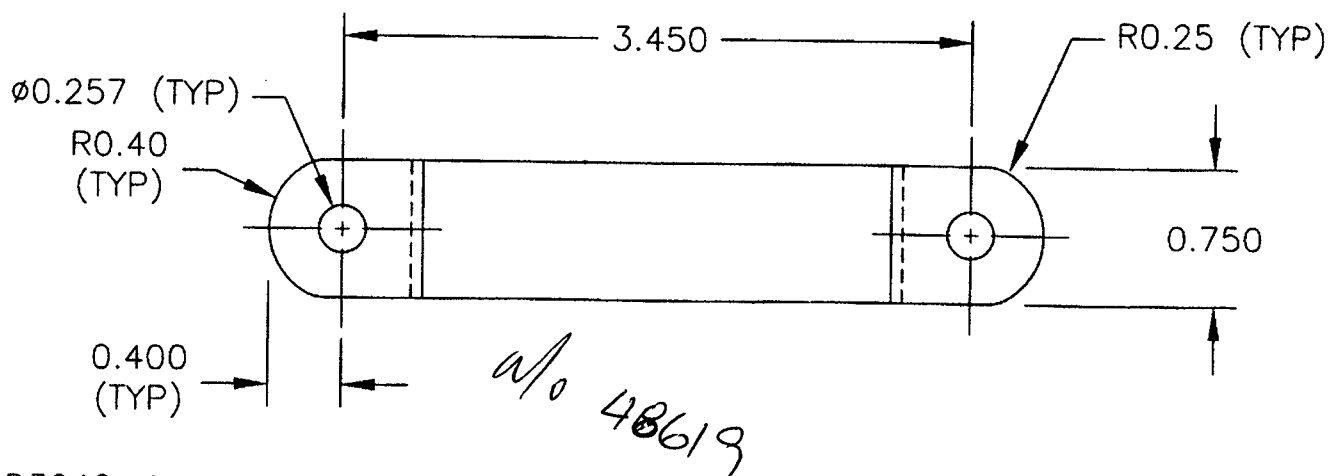
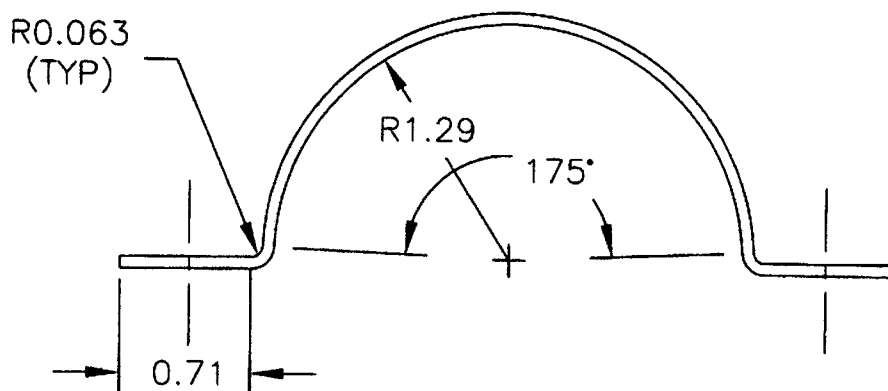
MF
09-04-09

DART



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3042	REV. A SHEET 1 OF 1
DATE 01.06.29		TITLE CLAMP	SCALE 1:1
A	01.06.29	NEW ISSUE	

RELEASED
01.07.09



D3042-1

- 1) MATERIAL: AISI 304/316 SS ANNEALED PER AMS 5513/5524
0.063 THICK
- 2) FLAT LENGTH: 5.713 END-TO-END
4.913 HOLE-TO-HOLE
- 3) BREAK ALL SHARP EDGES 0.005-0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Bill Beckett

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 2, 2009 1:16 AM
To: 'Bill Beckett'
Subject: RE: D119-675-012

Bill,

I got called late on Friday before I left for Kelowna and had to make a quick decision to send this off to Skyline "no charge" at the request of Agusta.

Grant has no interest in the step. I already tried that while I was there. The step was installed on the aircraft for maybe 5 flights where I was aware of exactly what was happening to the step.

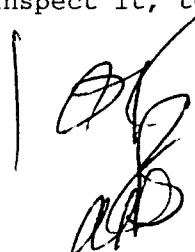
(Still in Dart control???)

It is tertiary structure and doesn't see very high loads in flight. We could probably equate this to doing a trial fit in the shop.

In this case, I think that we can receive the step in, inspect it, touch up as necessary, and re-sell as new.

The hardware and rubber cushions should be replaced. We should give it a new b/n and new labels.

David



-----Original Message-----

From: Bill Beckett [mailto:bbeckett@dartaero.com]
Sent: Monday, June 01, 2009 7:08 AM
To: 'David Shepherd'
Subject: D119-675-012

David,

This step was sent "no-charge" to Skyline for testing with the basket, crosstubes etc. for vibration analysis.

Is this step still saleable as new? Or is it now "serviceable"? If serviceable, any suggestions how to dispose of it? Would Grant buy it?

Thanks,
Bill

No virus found in this incoming message.

Checked by AVG - www.avg.com

Version: 8.5.339 / Virus Database: 270.12.48/2147 - Release Date: 05/31/09 20:45:00